

Split

Work Order ID 125066-2

125066

Page 1

Tuesday, October 07, 2014 10:34:26 AM

Item ID: D3690-041 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Glareshield Assembly

Start Date: 10/06/14 Start Qty: 2.00 *2*

Cust Item ID:

Required Date: 10/06/14 Req'd Qty: 2.00 *2*

Customer:

Reference:

Approvals: Process Plan: MCS Date: 14-10-07 Tooling: _____ Date: _____ Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3690	Rev C

100	Pick Kit	0.00				1	FF	JUN 04 2015
100								
Packaging	Memo	0.00						
Packaging								

110	Small Fab	0.00				1	FF	JUN 04 2015
110								
Small Fab	Memo	0.00						
Small Fab	1- transfer drill D3697-041 and D3698-1 in D3690-1 and assemble as per dwg D3690							
	USE DT9809							
	2- scribe batch # and part # as per dwg							

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: AdA Date: 15/06/30QA Closed: RBN Date: 15/06/23

Work Order: <u>125066</u>	DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Work Order Update ☐	AGAINST DEPARTMENT/PROCESS			
Part No. <u>D3690 041</u>		Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
NCR No. <u>15-5125</u>		Machining ☐	Small Fab ☒	Prod. Eng. Coord. ☐	Quality ☐
		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
		Large Fab ☐	Composite ☐	Supplier ☐	

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	<u>15.06.02/110</u>	<u>1</u>		HOLE FOR D3697-041 WAS DRILLED IN WRONG LOCATION. RC: Human error/ LACK OF ATTN.	DAS 22 9-89 15.06.02	Fill HOLE WITH MAGNOBOND B/N: <u>M131818</u> <u>M130986</u> AND SAND SMOOTH. REF: D3690-041 B41932	FF JUN 02 2015	DAS 30 9-89 15.06.03	PD 15.06.03
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear	General		
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☒ Positioned Wrong
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge
☐ Ripples in Bend	☒ Drill Holes	☐ Offset	☐ Pressure/Forced
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	☐ Temperature/Cure
☐ Turning Sequence	☐ Finish	☐ Out of Sequence	☐ Weld
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions	☐ Wrong Stock Pulled
			☐ Other

Work Order ID 125066

Tuesday, October 07, 2014 10:34:26 AM

125066

Page 2

Item ID: D3690-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Glareshield Assembly

Start Date: 10/06/14 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 10/06/14 Req'd Qty: 2.00 ***2*** Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				1			DAS 38 9-89 JUN 08 2015
130 *130* SprayPaint Spray Painting	SprayPaint Memo 1- Mask hatched areas (6 pls) on inside of the part prior to painting as per dwg 2-Paint D3690-041 assy flat black using Basf Glasurit 22 Line code SFA39.50 per Dart QSI 005 4.2 primer 130170 paint 130178	0.00 0.00				1			DAS 41 9-89 15-6-14
140 *140* QC Quality Control	QC14- Inspect Spray Paint Memo	0.00 0.00				1			DAS 38 9-89 JUN 19 2015

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Work Order Update ☐	AGAINST DEPARTMENT/PROCESS			
Part No. _____		Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
NCR No. _____		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐
		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
		Large Fab ☐	Composite ☐	Supplier ☐	

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear	General		
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge
☐ Ripples in Bend	☐ Drill Holes	☐ Offset	☐ Pressure/Forced
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	☐ Temperature/Cure
☐ Turning Sequence	☐ Finish	☐ Out of Sequence	☐ Weld
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions	☐ Wrong Stock Pulled
			☐ Other

Work Order ID 125066

125066

Page 3

Tuesday, October 07, 2014 10:34:26 AM

Item ID: D3690-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Glareshield Assembly
 Start Date: 10/06/14 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 10/06/14 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <u>ST447</u>	0.00							
150									
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

1 NO DA8 27 9-89 JUN 20 2015
ML5 JUN 22 2015
ML5 JUN 22 2015

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Work Order Update ☐	AGAINST DEPARTMENT/PROCESS			
Part No. _____		Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
NCR No. _____		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐
		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
		Large Fab ☐	Composite ☐	Supplier ☐	

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric to O/S ☐ Cracks ☐ Crushed/Crimped ☐ Cuffs ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Nipples in Bend ☐ Torque Waves in Extrusion ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damaged ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drill Holes ☐ Drawing ☐ Finish ☐ Folio	☐ Grain ☐ Hardware ☐ Inspection Incomplete ☐ Instructions Incomplete/Unclear ☐ Maintenance ☐ Mislabeled ☐ Misread ☐ Offset ☐ Out of Calibration ☐ Out of Sequence ☐ Outside Dimensions	☐ Ovalized ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge	☐ Pressure/Forced ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
---	---	---	--	---

Picklist Print

Tuesday, October 07, 2014 10:34:26 AM

Page 1

Work Order ID: 125066

125066

Parent Item: D3690-041

D3690-041

Parent Item Name: Glareshield Assembly

Start Date: 10/06/14

Required Date: 10/06/14

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-04-29 new issue DD verified by:ec
IPP Rev:B 08-07-14 revB as per dwg DD verified by:ec
IPP Rev:C 08-09-08 added painting DD verified by:EC
IPP Rev:D 08-10-07 revC as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
CR3213-4-03 rivet		Purchased	No				Each	186.0000		70			
**											FF	JUN 04 2015	
			<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>						
			ST320		186								
			121708		19								
			m127831		3								
			m128634		64								
			m129913		100								
D3690-1 Glareshield		Manufactured	No				Each	1.0000		2			
**											FF	JUN 04 2015	
			<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>						
			ST400		1								
			116874		1								
D3697-041 Tube Assembly		Manufactured	No				Each	0.0000		2			
**											FF	JUN 04 2015	
D3698-1 Support Angle		Manufactured	No				Each	0.0000		2			
**											FF	JUN 04 2015	

82743

Picklist Print

Page 2

Tuesday, October 07, 2014 10:34:26 AM

Work Order ID: 125066

125066

Parent Item: D3690-041

D3690-041

Parent Item Name: Glareshield Assembly

Start Date: 10/06/14

Required Date: 10/06/14

Start Qty: 2.00

Required Qty: 2.00

MS20426AD3-5

Purchased

No

Each

6,508.000

4

MS20426AD3-5

**

FF

JUN 04 2015

Rivet

Location

Loc Qty

Loc Code

ST314

6508

4444

1710

4533

4798

92

NAS1149DN332J

Purchased

No

Each

598.0000

4

NAS1149DN332.J

**

FF

JUN 04 2015

Washer

Location

Loc Qty

Loc Code

ST277

598

m127306

100

m127831

498

42